

Date: Monday, 3/17/2008 11:57:07 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD X-TUBE
Job Number	: 38034		
Estimate Number	: 10006		
P.O. Number	:	Part Number	: D2889
This Issue	: 3/17/2008 S.O. No. :	Drawing Number	: D2889 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 36619	Material	:
Written By	:	Due Date	: 4/4/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>18080317</u>		
Comment	: Est Rev:A New Issue 05-10-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube material

Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	B23963

DP 8-4-8

2.0	BENDING	BENDING MACHINE
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Comment: LANDING GEAR RESOURCE 1
 1-Bend D2889 as per Dwg D2889 and Folio FT001

EL 8-4-8

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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see attachment

MF 08-04-07

Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

S 08/04/08 (FO)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and alodine as per QSI 005 4.1
 Inside and outside of tube

u/a S ooduylog
 used in w/lo #37947

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:57:07 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

S 08/04/00
used on w/o # 37947

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/00

Job Completion



W. S. M. 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

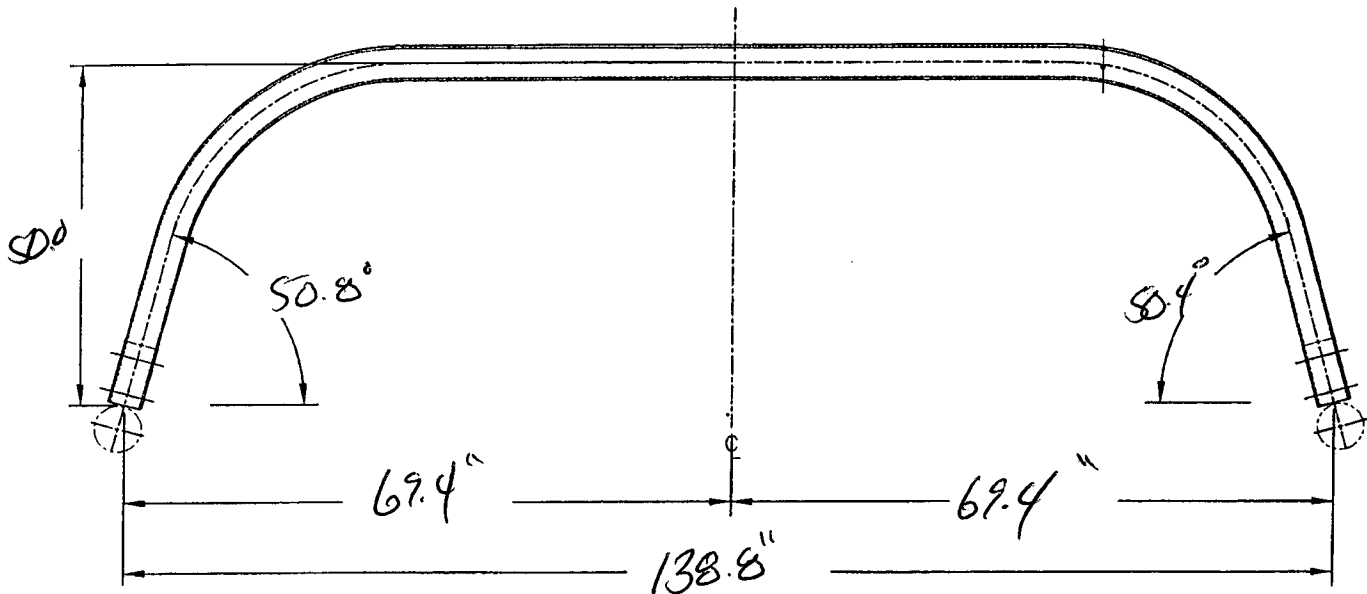
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38034
Description: Crosstube Fwd		Part Number:	D2889
Inspection Dwg: D2889 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
* used on w/lot 37947

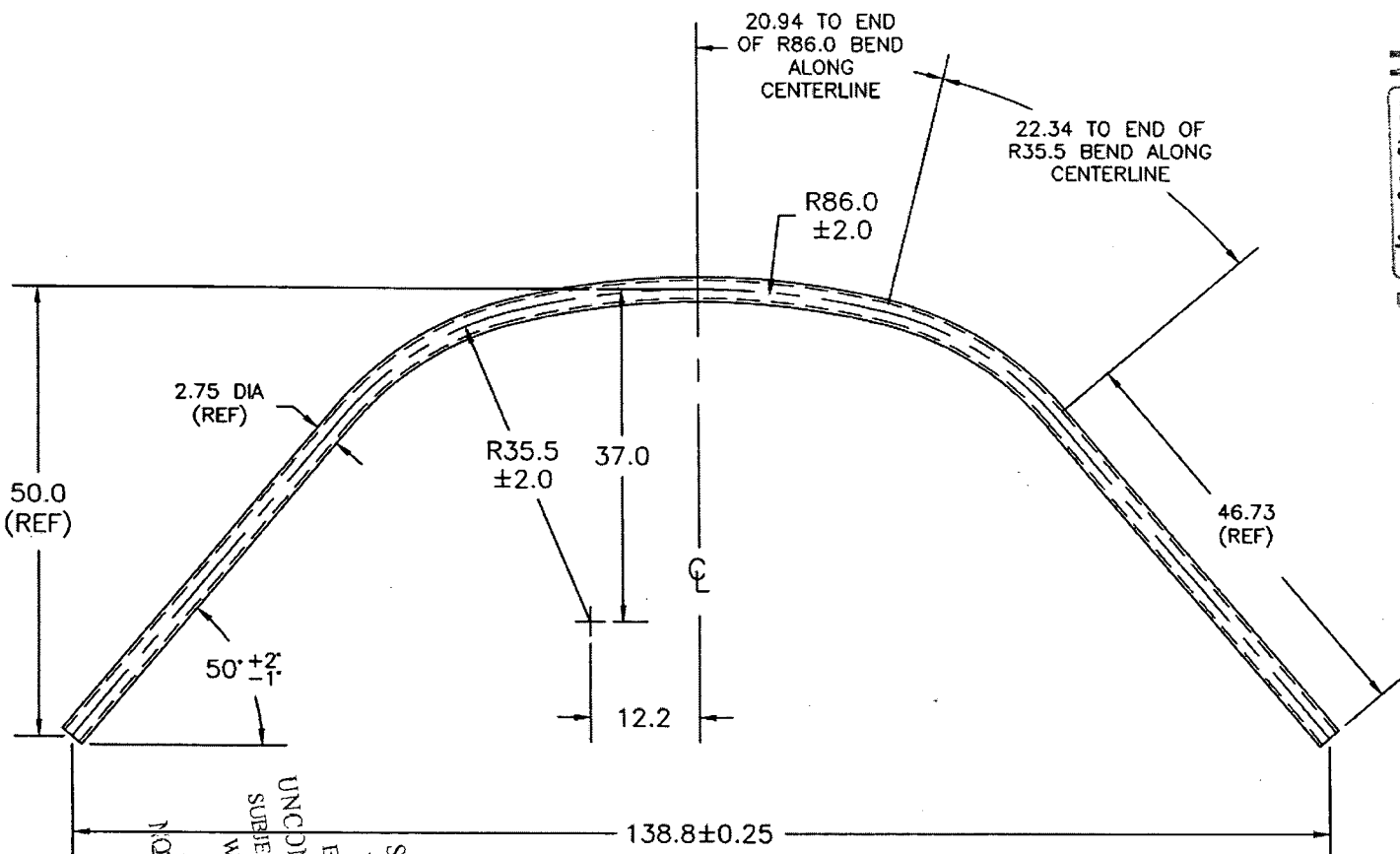
QC15 Inspection	08/04/08
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

QACOPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1	
DATE	TITLE		SCALE	
02.10.18	FWD CROSSTUBE		1:20	
A	99.05.21	NEW ISSUE		
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES		

02.10.28 *af*



- 1) MATERIAL: MANUFACTURE FROM D6005-180 (ø2.75 OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

SHOP COPY
RETURN TO
ENGINEERING
UNC CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 38034

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Date: Friday, 04/04/2008 1:07:51 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD X-TUBE
Job Number	: 38034		
Estimate Number	: 10006		
P.O. Number	:	Part Number	: D2889
This Issue	: 04/04/2008 S.O. No. :	Drawing Number	: D2889 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 17/03/2008 Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 36619	Material	:
Written By	:	Due Date	: 04/04/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 05-10-25 JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish



Handwritten signature and date 060411

Job Completion



REFERENCE ONLY

Handwritten signature